



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A94-3700-A-01
Job Sheet 181157



Part No: RBE350A94-3700-A-01

Job Qty: 30 ea

Part Name: Tube



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/23/18

Job Tracking No:

Due Date: 9/4/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBE350A94-3700-A Rev 7 IPP Rev A 18.01.16 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea	9/4/18	9/4/18	0.00	0.00	Start Up Machining-4		JB 18-12-11
110	CNC Lathe	30 pcs	9/4/18	9/4/18	0.00	7.50	SL-154		JB 18-12-11
120	QC	30 pcs	9/4/18	9/4/18	0.00	0.00	QC2		JB 18-12-11
130	QC	30 pcs	9/4/18	9/4/18	0.00	0.00	QC8		JB 18-12-11
135	HandFinish	30 pcs	9/4/18	9/4/18	0.00	3.00	HandFinish7		JB 18-12-11
150	Outsource	30 pcs	9/4/18	9/4/18			GRO002-VC	10	JB 18-12-11
160	Packaging	30 pcs	9/4/18	9/4/18	0.00	0.00	Packaging2		JB 18-12-11
170	QC	30 pcs	9/4/18	9/4/18	0.00	0.00	QC6		JB 18-12-11
180	Packaging	30 pcs	9/4/18	9/4/18	0.00	0.00	Packaging3		JB 18-12-11
210	QC21-SA	30 Ea	9/4/18	9/4/18	0.00	0.00	QC21		JB 18-12-11

Part Op 110 - 1-Machine as per FOLIO FB780 FOLIO REV: _____ DWG REV: _____ 2-Deburr 3-Engrave T/N
Descriptions: And / or S/N number as required Using Marktronic engraver as per DWG.

135 - Bead blast

150 - Issue P/O to Groupe Altech; PO 042033 - Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-A513-T-0.750W0.085	A513 Seamless Alloy Steel Round Tubing 0.75"dia. x 0.085" Wall	36.6900 ft (1.223 ea)	90-Start up Operation	5098038

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-A513-T-0.750W0.085	37	124	0



Container No: S136777



Part: RBE350A94-3700-A-01

Job No: 181157

Serial No/Batch: S136777

Revision: 7

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

ifications

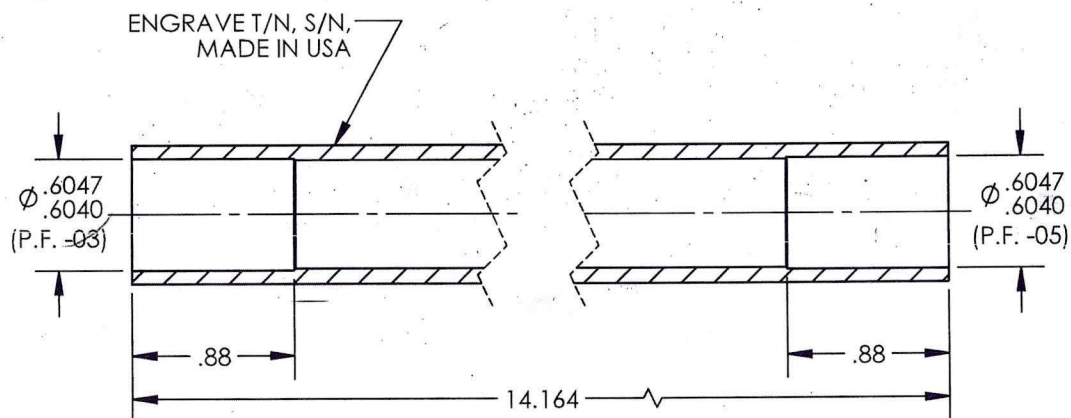
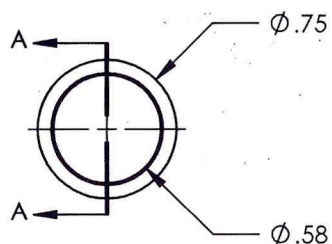
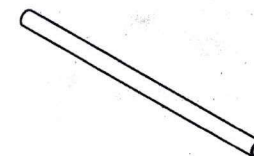
ould not be found.

Plex 12/10/18 5:10 PM DART.LAMARCHE.MATHIEU

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
6	15-0212	-01 CH'D OAL WAS 14.173 IS 14.164. ADDED ENGRAVE NOTE.	8/14/2015	RJC	JAG
7	16-0282	-01 ADDED DIMS Ø.6040-.6047 (P.F. -.03), .88, Ø.6040-.6047 (P.F. -.05), .88. ADDED FINISH BLACK OXIDE QMSI-6.2.2, B.O. REV D. CH'D MAT'L WAS STEEL IS DOM.	1/3/2017	DPD	JAG

FB780



SECTION A-A

(-01)

TUBE

DART AEROSPACE	
TITLE SWASHPLATE IMMOBILIZING TOOL LONG BRACE	
DWG NO. RBE350A94-3700-A-01	REV 7
MAT'L DOM	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC QMSI-6.2.2, B.O. REV D	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125°
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EUROCOPTER AS350/355
SCALE 1:1	DATE 8/21/2012 SHEET 3 OF 5



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

PURCHASE ORDER **PO042033**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO042033
PO Date: 12/12/18
Due Date: 12/19/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185116	RBE117-68021W7	Pusher -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	12/19/18	4 pcs	0 pcs	4 pcs	\$3.4285714/pcs	\$13.71
2	181157	RBE350A94-3700-A-01	Tube -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	12/19/18	31 pcs	0 pcs	31 pcs	\$3.4285714/pcs	\$106.29

Grand Total: \$120.00



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PURCHASE ORDER PO042033

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

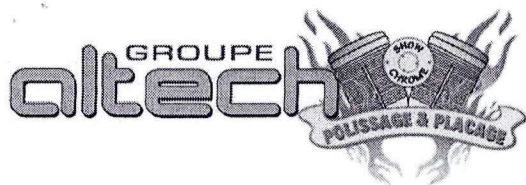
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/12/18 2:27 PM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(015344-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

015344 - 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
21-Dec-2018		Aman		042033				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE117-68021W7 Rev.	RBE117-68021W7 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS1 APPLY A THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1 WIPE OFF EXCESS	OXIDE-BLACK CH	4	4	0	0	0
2	RBE350A94-3700-A-01 Rev.	RBE350A94-3700-A-01 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	BLACK-OXIDE CH	31	31	0	0	0

 DAS
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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness
Inspecteur Qualité
Quality Inspector
Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.